Date:

Thursday, 12/07/2007 7:57:05 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 33518

Estimate Number

: 10369

P.O. Number This Issue

: 12/07/2007

: NC

Prsht Rev. First Issue

: //

S.O. No. :

: PURCHASED PARTS Type

: 24030 **Previous Run**

Written By

Checked & Approved By

Comment

: Est. A 98.11.09

Drawing Name

: 427 "I" BEAM

Part Number

: D2792130

: A1

Drawing Number

: D2792 REV A1 : N/A

Project Number **Drawing Revision**

Material

Due Date : 19/07/2007

Qty:

60 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

PG 1.0



Comment: PURCHASING

Issue P/O:

- a) Extrude as per Dwg D2792
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Tool: MS-19248
- d) Material certification is required.
- e) 130 is equal to 130.0"

EXTRUSION

PURCHASING

c 207/07/12



Comment: Qty.:

2.0

1.0000 Each(s)/Unit

60.0000 Each(s) Total:

EXTRUSION

D2792130P

3.0 PACKAGING 1 PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0



Comment: PURCHASING

PG

1-Send a sample for pull testing

2-Attach test report to W/O









Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
---------------------------	-------------	-------	------	-----

W/O:		WORK ORDER CHANGES		, , , , , , , , , , , , , , , , , , , ,			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
A4729	4.0	material catification for ASTM B-221, remove this step, perm change	E	07.07.24		10-12-23	6707-23
0707.23	\$.0		E	57.07.24		140723	barz

Part No:	PAR #: _	Fault Category:	NCR: Yes No	DQA:	Date:	
			QA: N/C CI	osed:	Date:	

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
*		Description of NC		Corrective Action Section B		Verification	Annroval	Ammunusi
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				,				
-								

NOTE: Date & initial all entries

User:

Thursday, 12/07/2007 7:57:05 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 427 "I" BEAM

Job Number: 33518

Part Number: D2792130

Job Number:



Seq. #:

Machine Or Operation:

DIMENSIONAL CHECK

Description:

5.0

Comment: DIMENSIONAL CHECK

Inspect Level 6

Check Test Report to Dwg D2792 for compliance

6.0

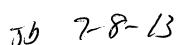
PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: L



7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



C207/08/13

Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·				
Part No	:	PAR #:	Fault Cat	egory:				Date: Date:	
NCR:		V	VORK ORE	DER NON-CONFORM					
		Description of NC		Corrective Action Sect	ion B	Vorifi	cation	Annessal	Ammanual
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Approval Chief Eng	Approval QC Inspector

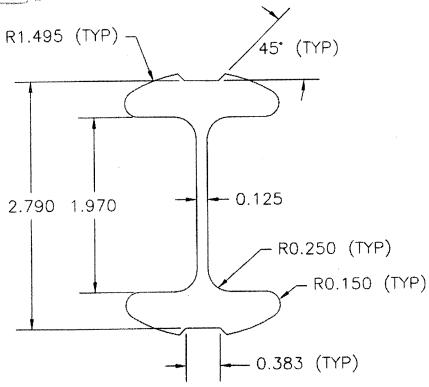
NOTE: Date & initial all entries





	DESIG	ig-	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
1	CHECK	(ED	APPROVED	DRAWING NO.	REV	·	A
		K6	(4A)	D2792 SHEET			
	DATE	<u></u>	1-7	TITLE	SC	AL	E
	98.0	08.13		EXTRUSION		1:	: 1
	Α		98.08.13	NEW ISSUE			
	Aı		01.04.17	ADD NOTE #7 of (1)			

RELEASE D



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM VIELD TENSILE STRENGTH = ...

MINIMUM YIELD TENSILE STRENGTH = 35 ksi MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL... PROPERTIES

- 2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
- 3. BREAK ALL SHARP CORNERS 0.010 MAX.
- 4. NO ID TOOLING MARKS.
- 5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6. ALL DIMENSIONS ARE IN INCHES.
- 7. PART NUMBER IS DZ79Z-XXX MHERE XXX IS CUT LENGTH IN WCHES (EG. DZ79Z-145 IS 145" LUG)

W/O 33518 04072



DART AEROSPACE ALTO TO

1270 ABERDEEN STREET HAWKESBURY, ONT

INDALEX LIMITÉE 325. RUE AVRO POINTE-CLAIRE (QUÉBEC) H9R 5W3 TÉL: 514-697-5120 • FAX: 514-694-8310

PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

D/C# . 613890

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES SPECIAL INSTRUCTIONS

WÊWE - SAWE

CUSTOMER P.S.T. : *6122-5207

K6A1K7

INDALEX G.S.T. REG NO: R136834041

Required Date: N.DU.CLIENT CUST. 1200 1 3 5 5 G.S.T. X.X.X.X.X.X. PROV. SALES TAX. DATE DE COMMANDE ORDEN DATO 7/12 N' DE COMM. DU CLIENT CUȘT PROER NO. NOTRE DATE DE COMMI CONDITIONS OUR GROEN DATE 12 TERMS ENVOYÉ PAR SHIPPED VIAOTTAWA 20 JUIL EN BALLOTS CARTONNÉ BUNDLED AND TAPED CARTONED DATE DE LIVRAISON DATE SHIPPED/07/19 COMMANDE ORDERED TATATOM TALLOMA LONGUEUR ALLIAGE ET TREMPAGE ALLOY AND TEMPER PRIX UNITAIRE EXTRUDE ONLY DUE=2007/08/02 ASAP 60 MS 19248 D2792130P 6061 3302 705 POIDS BUNDLE= 774727 7747 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

EXEMPLAIRE DE LA COMPTABILITÉ ACCOUNTING COPY

FEUILLE D'EMPAQUETAGE PACKING SLIP



325 ruo Avro Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120 Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer:

DART AÉROSPACE L'D

Adresse / Address :

1270 ABERDEEN STREET

HAWKESBURY ONT.

K6A 1K7

Commande Indalex / Indalex order # : 7071049

2792-130

Bon de commande / Purchase order

Matrice / Die # : MS 19248

Description: N/A

Alliage & trempage / Alloy & temper

6061

Contrôle / Control #: 息

Coulée / Cast #: 40861

	vlin,requis Alin,required	Résultat actual Actual Results
Tenaton ultime Ultimate stress (psl)	38 000	42161
Contrainte élaptique Yintg stress (psi)	35 000	39429
% élongation dans 2" % elongation in 2"	6	(12)
Dursté Rockwell & (hre) Rockwell & Hardness (hre)	88 @ 100	95

Composition chimique typique / Typical chemical composition:

	i2	le	Cu	Alm	Mg	۵	Zn	11
6063	0.20 - 0.60	0.35 Max	0,10 Max	E,10 Max	0,45 - 0,90	0,10 Max	0.10 Mox	0.10 Mgz
6005	0.60 - 0.90	0,35 Max	0,10 Mgx	C, TO Max	0,40 - 0.60	0.10 Max	0,10 Max	0,10 Max
6005A	0.69 - 0.72	0,15 - 0,27	0,08 - 0,12	0 20 ~ 0,24	0,48 - 0,52	0.03 Max	0.05 Mgx	0.03 MOX
6061	0.40 - 0.80	0,70 Max	0,15 - 0,40	(1,15 Max	0.80 - 1,20	0,04 - 0.35	0.25 Max	0,15 Max
4951	0.7 - 1.3	0.5 Max	0,10 Max	C.40 - 0.80	0.40 - 0.80	-	0,20 Mox	0,20 Max

Nous certifions que le matériei fourni rencontre les exigences chimiques telles qu'afinoricées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AM\$ QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client-

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of spectmen) and AMS QQA 200/8 accept for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre.

date: 2007-07-18

OFFI-D. her

SOC

Yours truly,

Mark Oliver Kokiong Technicien de la qualité Quality technician

Indalex Limited

913-935-254€

Dart Rerospace

18 Jul 2007 1:28PM